

Date: Thursday, 07/12/2006 6:55:36 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 29769	
Estimate Number : 10584	
P.O. Number : N/A	Part Number : D1048
This Issue : 07/12/2006 S.O. No. : N/A	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 29769	Material : N/A
Written By : <u>W</u>	Due Date : 15/01/2007 Qty: 50 Um: Each
Checked & Approved By : <u>W</u>	
Comment : Est: B 02.02.22 Re-format NG	
Est Rev:C Now on Waterjet 06-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0116 sf(s)/Unit Total: 0.5775 sf(s)

304/316 .063 Sheet

Batch: M101873ml 07/01/05

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D1048

Dwg Rev: AProg Rev: Aml 07 01 0950

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 01 0950

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

11-01-07 50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

SB 11-01-07 50

Date: Thursday, 07/12/2006 6:55:36 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29769

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2010 using DT8053

FF 07-01-26

PTO

49

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/29 (49)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-B/a.m

07/01/31

M/100700

(49x)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/02/06 (49)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/02/06 (49)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/07 (49)

Job Completion



U 07.02.07

Date: Tuesday, 12/5/2006 8:14:16 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 29769	
Estimate Number : 10584	
P.O. Number :	Part Number : D1048
This Issue : 12/5/2006 S.O. No. :	Drawing Number : D1048 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 27091	Material :
Written By :	Due Date : 1/15/2007 Qty: 50 Um: Each
Checked & Approved By : <i>06 12 05</i>	
Comment : Est: B 02.02.22 Re-format NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: _____

Stamp and deburr per dwg D1048

Material: Stainless steel 7304#2B Supply release not for Material.

**OLD SF
m20151614
Water Jet*

2.0

D1048F

Clamp



Comment: Qty.: 1.0000 U(s)/Unit Total : 50.0000 U(s)
CLAMP

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

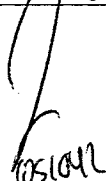
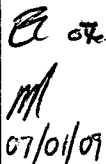
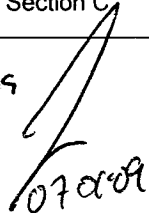

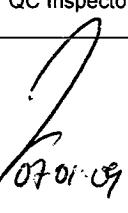

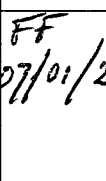

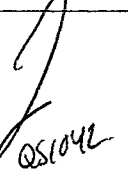
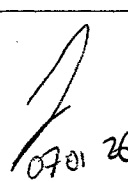
1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.

2-Form as per dwg D2010 using DT8053

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 07/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/09	2.0	DDXF was wrong holes were 1.38 center to center, but were supposed to be 1.705		Fix Program Program , Destroy Pieces and re-cut	 07/01/09	 07/01/09	 07/01/09	 07/01/09
07/01/26	6.0	Bracket off center		Scrap + Destroy No replace.	 07/01/26	 07/01/26	 07/01/26	 07/01/26

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:14:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29769

Part Number: D1048

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/09/02 RCL

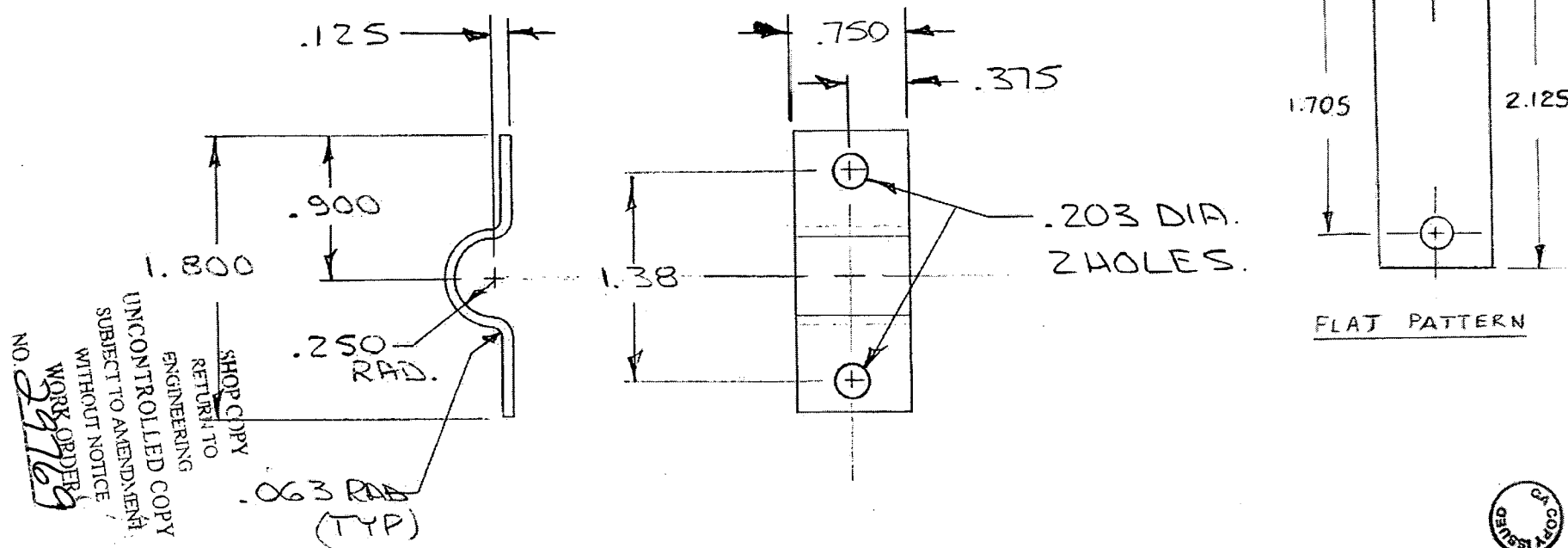
NOTES:

1) MATERIAL

STAINLESS STEEL
T304#2B .062 THICK

2) FINISH : POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)
PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.010 TO 0.020



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29769

A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.	RIVET CODE SHALL BE PER HAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR		
	RF		DRAWN	BASIC CODE	DIA. DASH NO. IN-HEAD NEAR SIDE F-HEAD FAR SIDE	CONTRACT NO.	DART AERO ACCESSORIES INC. VANCOUVER CANADA				
			APPROVED	D-DIMPLE DIGIT=NO OF SHEETS C-COUNTERSINK	LENGTH DASH NO. W-SPOTWELD	DRAWN BRADLEY	DATE 5/1/97				
			DESCRIPTION OF CHANGE	BASIC CODES BJ-M520470AD BB-M520470AD		DESIGN BRADLEY	TITLE CLAMP				
		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED			CHECKED		CODE	DWG NO. D1048	REV. A		
		GENERAL	LIMITS		CUSTOM		SCALE 1:1	SHT 1 OF 1			
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 μ 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - S - 7742 5. HOLES PER AND 10307	1. TOLERANCES — JXX ± .030 JXX ± .010 2. ANGLES 3 1/4° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MFC CENTRE LINES .005		REPORT ALL DISCREPANCIES — DO NOT SCALE						

D1048

DART AEROSPACE LTD	Work Order: 29769
Description: Clamp	Part Number: D1048
Inspection Dwg: D1048 Rev: A	Page 1 of 1

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
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[illegible]

Measured by:	<i>MLM</i>	Audited by:	<i>DD</i>	Prototype Approval:	
Date:	<i>07/01/09</i>	Date:	<i>07/01/09</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	